

Date: Tuesday, 5/16/2006 10:41:00 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 27148		
Estimate Number	: 10832		
P.O. Number	: N/A	Part Number	: D29322
This Issue	: 5/16/2006 S.O. No. : N/A	Drawing Number	: D2932 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26368	Material	: N/A
Written By	: <i>See comment below</i>	Due Date	: 6/5/2006
Checked & Approved By	: <i>06.08.16</i>	Qty:	6 Um: Each
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
7075-T7351 2X6.25X7.875
Issue material from stock: 7075-T7351 (QQ-A-250/12)
Cut Size 2.0 x 6.25 X 7.88
Grain Along Long 7.88 Length
Batch No: *024891*

SL 06/06/10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
5-Deburr

SL 06/06/10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

SL 06/06/11

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SL 06/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:41:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 27148

Part Number: D29322

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7th 06/06/14

6

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAN

06:06:11

6

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC

06 06 13

(6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/06/14 (6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST475*

06/06/14 (6)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/14

(6)

Job Completion



U 06/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27148
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.119	.118	.120		
B	0.100	0.140		.119	.118	.118	.119		
C	0.100	0.140		.121	.119	.120	.120		
D	0.210	0.230		.223	.219	.220	.219		
E	1.245	1.255		1.249	1.248	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.501	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.578	1.577		
J	2.495	2.505		2.499	2.501	2.501	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.240	.240	.239		
N	0.100	0.140		.121	.122	.123	.121		
O	0.540	0.560		.551	.552	.552	.550		
P	0.490	0.510		.504	.504	.503	.503		
Q	3.715	3.725		3.720	3.719	3.721	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.258	.258	.257	.258		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.631	1.630		
V	1.362	1.372		1.367	1.367	1.366	1.365		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.133	1.131	1.131	1.132		
Y	1.565	1.585		1.572	1.571	1.572	1.570		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	06/06/10

Audited by:	gmk
Date:	06/06/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD	Work Order: 27148
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. B	Page 1 of 1

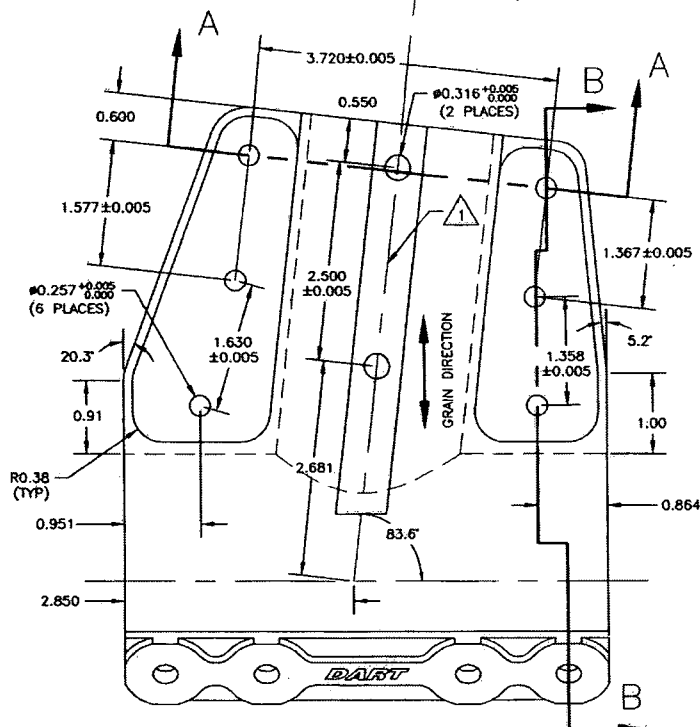
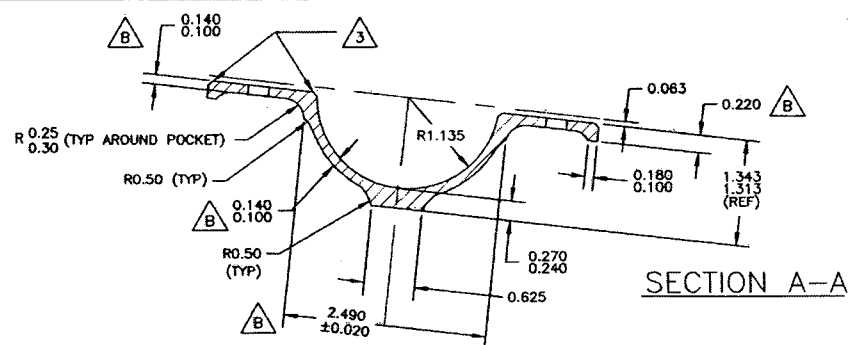
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.118				
B	0.100	0.140		.120	.119				
C	0.100	0.140		.121	.120				
D	0.210	0.230		.220	.219				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.251				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.578	1.577				
J	2.495	2.505		2.501	2.501				
K	0.257	0.262	DT8683	/	/				
L	0.312	0.317	DT8686	/	/				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.117	.121				
O	0.540	0.560		.552	.551				
P	0.490	0.510		.500	.502				
Q	3.715	3.725		3.720	3.719				
R	2.470	2.510		2.495	2.495				
S	0.240	0.270		.259	.258				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	/	/				
X	1.125	1.145		1.127	1.131				
Y	1.565	1.585		1.566	1.570				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject -									

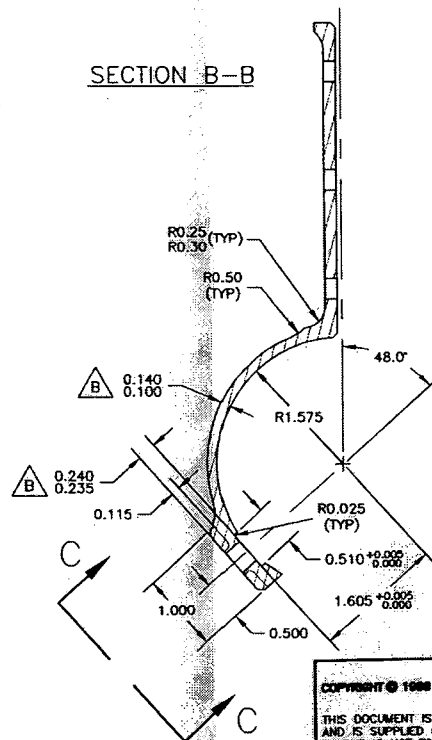
Measured by: J.L
Date: 06/06/11

Audited by: [Signature]
Date: 06/06/11

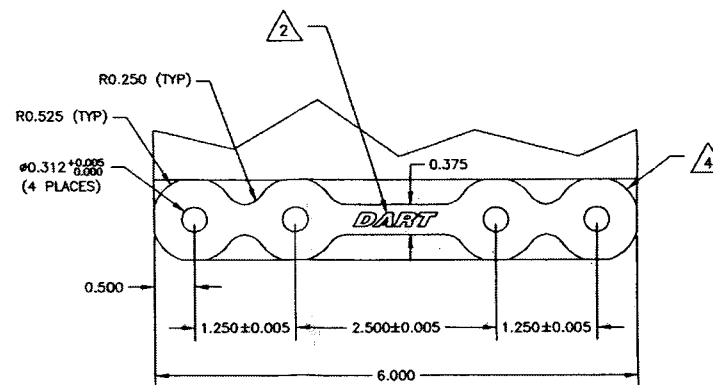
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF [Signature]	[Signature]



SECTION B-B



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27148



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (Q0-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
00.05.31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE 00.05.29		TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

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